

Date: Monday, 06/11/2006 9:20:02 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D412-664-203	
Job Number	: 29271		Part Number	: D412664203	
Estimate Number	: 10804		Drawing Number	: NCR 095	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 06/11/2006	S.O. No.	: N/A	Drawing Revision	: N/A
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 13/11/2006	
Previous Run	: 29190		Qty:	1	Um: Each
Written By	:				
Checked & Approved By	:				
Comment	:				

## Additional Product

Job Number:				PN: D412-664-203		GHG	CHG003
				DESC: Crosstube Aft High		SIC	SH01-9
				LOT: B27084	MODEL: Bell 412	SIC	SR01298NY
MADE IN CANADA							

Seq. #: Machine Or Operation: Description

1.0	PACKAGING 1	PACKAGING RESOURCE 1	
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Comment: PACKAGING RESOURCE #1  
 REMOVE FROM STOCK  
 D412-664-203  
 RECORD B/N'S

327084

18/06/2006

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
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Comment: LANDING GEAR RESOURCE 1  
 REMOVE SUPPORT D2896-1  
 FROM CROSSTUBES AND LABEL SUPPORT  
 WITH B/N OF CROSSTUBE IT CAME OFF OF

2T 06-11-01 ①

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
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Comment: LANDING GEAR RESOURCE 1  
 REMOVE CENTRE ABRASION STRIP  
 AND CLEAN OFF ALL ADHESIVE RESIDUE

2T 06-11-01 ①

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Drawing Name: D412-664-203

Job Number: 29271

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

18/06/11 01:01

5.0	SPRAY PAINTING	SPRAY PAINTING
-----	----------------	----------------



Comment: SPRAY PAINTING  
RE-PAINT SECTION OF CROSSTUBE  
BETWEEN THE TWO CHAFING SHIELDS  
AS PER QSI 005

11/06/11 23:01

01

6.0	QC14	Inspect Spray Paint
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Comment: Inspect Spray Paint

18/06/11 30:01

7.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1  
INSTALL SUPPORT D2896-1  
USING MAGNOBOND 6398 B 11/02/2017  
ENSURING B/N MATCHES CROSSTUBE  
AS PER DSI 9357  
REPLACE CLAMPS  
2 X MS21920-30 B 14/01/2016  
ADD RUBBER CUSHION  
2 X D2182B (D2182B058) B 28/04/12

18/06/11 30:01

8.0	MS2192030	clamp(per MIL-DTL-8783C)
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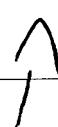
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
clamp(per MIL-DTL-8783C)



9.0	D2182B	Neoprene Cushion-.750 bl
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Comment: Qty.: 0.9600 f(s)/Unit Total : 0.9600 f(s)  
Neoprene Cushion-.750 bl



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Job Number: 29271

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
10.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	11/06/11/30 (1)
11.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	11/06/11/30 (1)
12.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 REPACKAGE PER PPP	Rev E 06/12/20 (1) add 2 copy of DST9357 to paper work
13.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	11/06/12/21 (1)

Job Completion



11/06/12/21

**DART**

DESIGN <i>b</i>	DRAWN BY <i>b</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. DSI 9357	REV. A SHEET 1 OF 2	
DATE 06.10.25		TITLE CROSSTUBE SUPPORT CHANGE	SCALE NTS	
A	06.10.25	NEW ISSUE		

## **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-664 Rev. C AND  
 INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D212-664 Rev. 2  
 REF. CANADIAN STC: SH01-9  
 REF. FAA STC: SR01298NY

For D412-664-203 Aft Crosstubes at CHG 002 or later, the D2856-600-1087 Abrasion Strip has been removed, the center D2896-1 Support has been bonded onto the crosstubes using Magnobond 6398 and D2182B058 Rubber Cushions have been installed underneath the MS21920-30 Clamps. Amend Parts List of IIN-D212-664 Section 5 and ICA-D212-664 Section 32.8 as follows:

**Remove:**

Item	QTY -203	Part Number	Description
32	1	D2856-600-1087	ABRASION STRIP

**Add:**

Item	QTY -203	Part Number	Description
41	2	D2182B058	RUBBER CUSHION

To prevent the center support from shifting on D412-664-203 Crosstubes at CHG 001, the D2896-1 Support should be removed and re-installed as follows:

- 1) Follow section 32.1 of ICA-D212-664 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty(2) MS21920-30 Clamps from the crosstube that fasten the D2896-1 Supports to the crosstube.
- 3) Remove the D2856-600-1087 Abrasion Strip from the crosstube per section 32.5 of ICA-D212-664.
- 4) Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection. Touch up finish per item 5.3.9 of 300 hour inspection.
- 5) Apply a 0.03" to 0.06" thick layer of Magnobond 6398 underneath D2896-1 Support and re-install the Support on the crosstube as shown in Figure 1. Use rocker beam assembly to properly align the D2896-1 Support. Ensure the Rocker Beam Assembly can move freely without any friction with other parts. Install a D2182B058 Rubber Cushion on each MS21920-30 Clamp. Position and secure the D2896-1 Support on the crosstube using MS21920-30 Clamps. Torque clamps 80-100 in-lb. Let the D412-664-203 Crosstube Assembly cure before re-installing the crosstube or the aircraft.
- 6) Re-install the D412-664-203 crosstube per section 32.2.5 through 32.2.9 of ICA-D212-664.

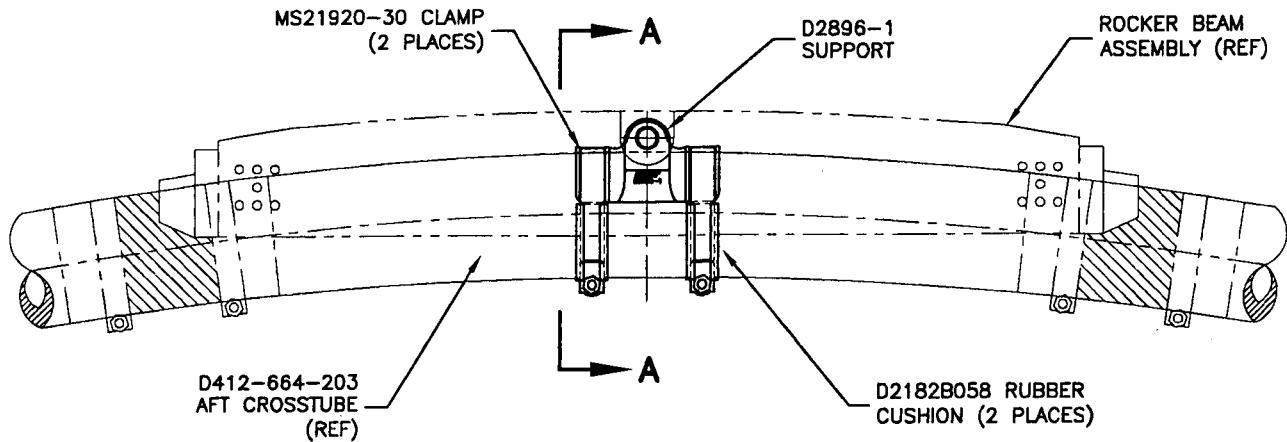
CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>Blair</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	06.10.25
CERT. NO.:	SH01-9
ISSUE:	3

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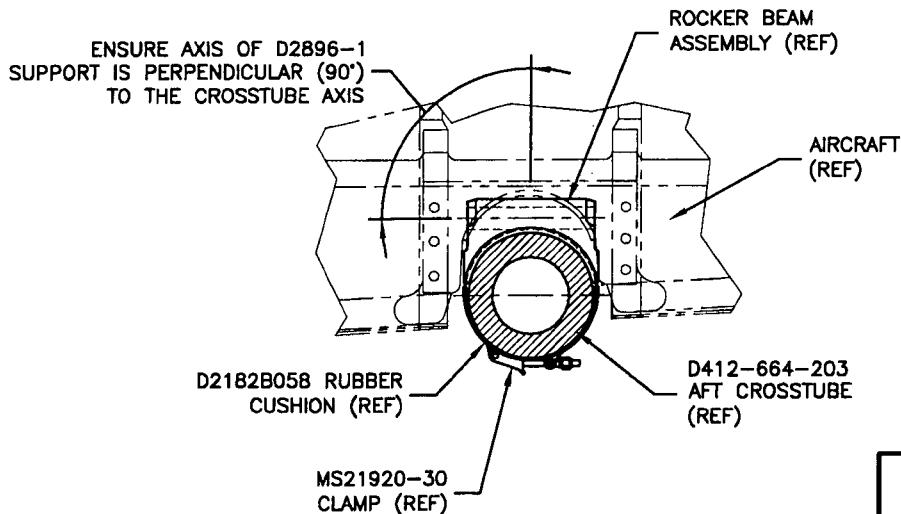
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**DART**

DESIGN <i>JB</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>CH</i>	DRAWING NO. DSI 9357	REV. A SHEET 2 OF 2
DATE 06.10.25		TITLE CROSSTUBE SUPPORT CHANGE	SCALE NTS



**FIGURE 1 - CROSSTUBE SUPPORT  
INSTALLATION ON D412-664-203**



**SECTION A-A**  
AIRCRAFT BODY SHOWN  
AS REFERENCE

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-0-01	
APPROVED <i>R. Shepherd</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	06.10.25
CERT. NO.:	SH01-9
ISSUE:	3

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